



Dart Aerospace Ltd.
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Canada

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D3172-041
Job Sheet 207126



Part No: D3172-041

Job Qty: 1 pcs

Part Name: Basket Base Assembly



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 2/19/20

Job Tracking No:

Due Date: 3/30/20

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG REV D IPP Rev:B 04.01.05 Added Step 5 inspection KJ/RF IPP Rev:C 08-08-29 revC as per dwg DD verified by:EC IPP Rev:D 11.04.04 added pressure wash DD VERF:EC IPP REV:E 16.11.03 AS PER DWG REV.D DD VERF:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Large Fab - Welded Assy-1	1 pcs	3/30/20		0.00	33.33	Large Fab - 1		
							Large Fab - 10		
							Large Fab - 2		
							Large Fab - 3		
							Large Fab - 4		DAS
							Large Fab - 5		43
							Large Fab - 6		9-89
							Large Fab - 7		
							Large Fab - 8		
							Large Fab - 9		
							Large Fab - 11 (Various)		
							Large Fab - 12		
110	QC 9	1 pcs	3/30/20		0.00	0.00	QC 9 - 10		
							QC 9 - 18		
							QC 9 - 24		DAS
							QC 9 - 43		24
							QC 9 - 50		9-89
							QC 9 - 9		
120	QC 5	1 pcs	3/30/20		0.00	0.00	QC 5 - 10		
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		
							QC 5 - 19		
							QC 5 - 22		
							QC 5 - 24		DAS
							QC 5 - 3		24
							QC 5 - 43		9-89
							QC 5 - 49		
							QC 5 - 51		



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Container No: S261832



Part: D3172-041

Job No: 207126

Serial No/Batch: S261832

Revision: rev.D

Inspector:

Exp Date:

Instructions: Various STC's

Date: 03/09/20

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						QC 5 - 58	
						QC 5 - 68	
						QC 5 - 9	
						QC 5 - 50	
						QC 5 - 30	
						QC 5 - 40	
						QC 5 - 61	
						QC 5 - 81	
130 Handfinish - 2-1 Pressure- B4B	1 pcs	3/30/20	0.00	0.38	Handfinish - 2 - 1 - B4B		BEB 20-03-12
					Handfinish - 2 - 2 - B4B		
					Handfinish - 2 - 3 - B4B		
					Handfinish - 2 - 4 - B4B		
140 Powdercoat - 1 White GI(A)- B4B	1 pcs	3/30/20	0.00	1.04	Powdercoat - 1 - B4B		
					Powdercoat - 2 - B4B		
					Powdercoat - 3 - B4B		20-03-12
					Powdercoat - 4 - B4B		
145 Packaging 3-1 - Stock - B4B	1 pcs	3/30/20	0.00	0.00	Packaging 3 - 1 - B4B		20-03-17
					Packaging 3 - 2 - B4B		
					Packaging 3 - 3 - B4B		
					Packaging 3 - 4 - B4B		
					Packaging 3 - 5 - B4B		
					Packaging 3 - 6 - B4B		
					Packaging 3 - 7 - B4B		
					Packaging 3 - 8 - B4B		
					Packaging 3 - 9 - B4B		
					Packaging 3 - 10 - B4B		
					Packaging 3 - 11 - B4B		
					Packaging 3 - 12 - B4B		
					Packaging 3 - 13 - B4B		
					Packaging 3 - 14 - B4B		
					Packaging 3 - 15 - B4B		
					Packaging 3 - 16 - B4B		
					Packaging 3 - 17 - B4B		
					Packaging 3 - 18 - B4B		
					Packaging 3 - 19 - B4B		
					Packaging 3 - 20 - B4B		
					Packaging 3 - 21 - B4B		
					Packaging 3 - 22 - B4B		
					Packaging 3 - 23 - B4B		
					Packaging 3 - 24 - B4B		
					Packaging 3 - 25 - B4B		
					Packaging 3 - 26 - B4B		

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					Packaging 3 - 27 - B4B	
					Packaging 3 - 28 - B4B	
					Packaging 3 - 29 - B4B	
					Packaging 3 - 30 - B4B	
					Packaging 3 - 31 - B4B	
					Packaging 3 - 32 - B4B	
					Packaging 3 - 33 - B4B	
					Packaging 3 - 34 - B4B	
					Packaging 3 - 35 - B4B	
					Packaging 3 - 36 - B4B	
					Packaging 3 - 37 - B4B	
150 QC 21 - SA	1 pcs	3/30/20	0.00	0.00	QC 21 - SA - 21	DAS
					QC 21 - SA - 70	21
					QC 21 - SA - 53	9.88

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Part Op 100 - (Fabricate per Drwg) 1-Cut Qty 4 D3166-1 as per Dwg D3172 2-Cut 3/4" x 3/4" square tubing as per Dwg D3172 3-Descriptions: Drill holes in D3172-3 as per Dwg D3172 4-Deburr & Remove all markings from material 5-Weld all ribs as per Dwg D3172 using DT9444 6- Weld top D3174-1 ONLY bottom ones will be welded after mesh is install as per dwg 7- Weld D5365-1 as per dwg in (2) locations. From edge of back basket corn (without hinge) to bottom of D5365-1 lug. And (2) located at the front. 8- Weld mesh as per dwg 9- Use DT10465 jig to locate the bottom D3174-1 as per dwg

110 - (QC9- Inspect visual per QSI004- Fusion Welds)

120 - QC5- Inspect part completeness to step on W/O)

130 - (Pressure Wash per QSI005 4.3/ Clean and remove all markings)

146 - (White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum)COAT: START TIME: 1:10. OVEN TEMPERATURE:

375 FINISH TIME: 1:25. ***** 2nd coat if necessary ***** 2ND COAT: START TIME: OVEN TEMPERATURE: FINISH TIME:

145 - Identify as per dwg & Stock Location:)

150 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D2232-3	Basket Hinge	2 pcs (2 ea)	100-Large Fab - Welded Assy-1	5241004
D2327-3	Spacer Bushing	2 pcs (2 ea)	100-Large Fab - Welded Assy-1	5200139
D2581	Mounting Bracket	2 pcs (2 ea)	100-Large Fab - Welded Assy-1	5246180
D3166-1	Basket Hoop	4 pcs (4 ea)	100-Large Fab - Welded Assy-1	5244805
D3174-1	Mounting Lug	8 pcs (8 ea)	100-Large Fab - Welded Assy-1	5059376 5071679
D5365-1	Lug	4 pcs (4 ea)	100-Large Fab - Welded Assy-1	5258390
M304EX0.75-16F	Expanded Metal Flat SS	32 sf (32 ea)	100-Large Fab - Welded Assy-1	5236300
M304TS0.750W.065	304 Sq Tube .75X.75X.065W	51 ft (51 ea)	100-Large Fab - Welded Assy-1	5186554

DAS
43
9-89

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Large Fab - Welded Assy-1	D2232-3	2	16	0
	D2327-3	2	18	0
	D2581	2	46	0
	D3166-1	4	27	0
	D3174-1	8	11	0
	D5365-1	4	0	0
	M304EX0.75-16F	32	594	0
	M304TS0.750W.065	51	259	0

Part Specifications

Specifications could not be found.

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Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier Quality ☐			
Date : _____	Sequence #: _____	QTY Affected : _____		MRB (QSI042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
				QC / QA Coordinator	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					